

Date: Wednesday, 3/8/2006 10:38:47 AM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE
Job Number	: 26129 - 2		
Estimate Number	: 12165	Part Number	: D34753
P.O. Number	: NIA	Drawing Number	: D3475 REV A
This Issue	: 3/8/2006 S.O. No. : NIA	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: A
First Issue	: NIA	Material	: NIA
Previous Run	: NIA	Due Date	: 3/31/2006
Written By	: <u>See comment below</u>	Qty:	10 Um: Each
Checked & Approved By	: <u>06.03.08</u>		
Comment	: Est Rev: A New Issue 06-02-03 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------

PG



Issue P.O



Comment: Qty.: 0.1281 sf(s)/Unit Total : 0.7686 sf(s)

Pick:

304/316 0.018 SHEET

(M304S26GA)

Batch:

768

D34753F

2.0	SHEAR	SHEAR
-----	-------	-------

PG



Receive + Inspect



CY06103121 (10)

Comment: SHEAR

Cut Flat pattern 2.00" X 8.79" as per Dwg D3475

20 Q.C. 7/06/03/27

(9) PTO

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Roll as per Dwg D3475

3-Form Bead as per Dwg D3475 Using Rotary Machine.

4-Spot Weld as per Dwg D3475 and Dart QSI 018

5-Cut 69 Deg Angle as per Dwg D3475.

SB 06/04/12 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng-/ Prod Mgr	Approval QC Inspector
		One taken for sample	Do	2003/28	1	Barry	Barry

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Wednesday, 3/8/2006 10:38:47 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 26129

Part Number: D34753

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 06/04/12

8

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

GA

SP 06/04/12

8

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

SP 06/04/12

8

Job Completion



U 06-04-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

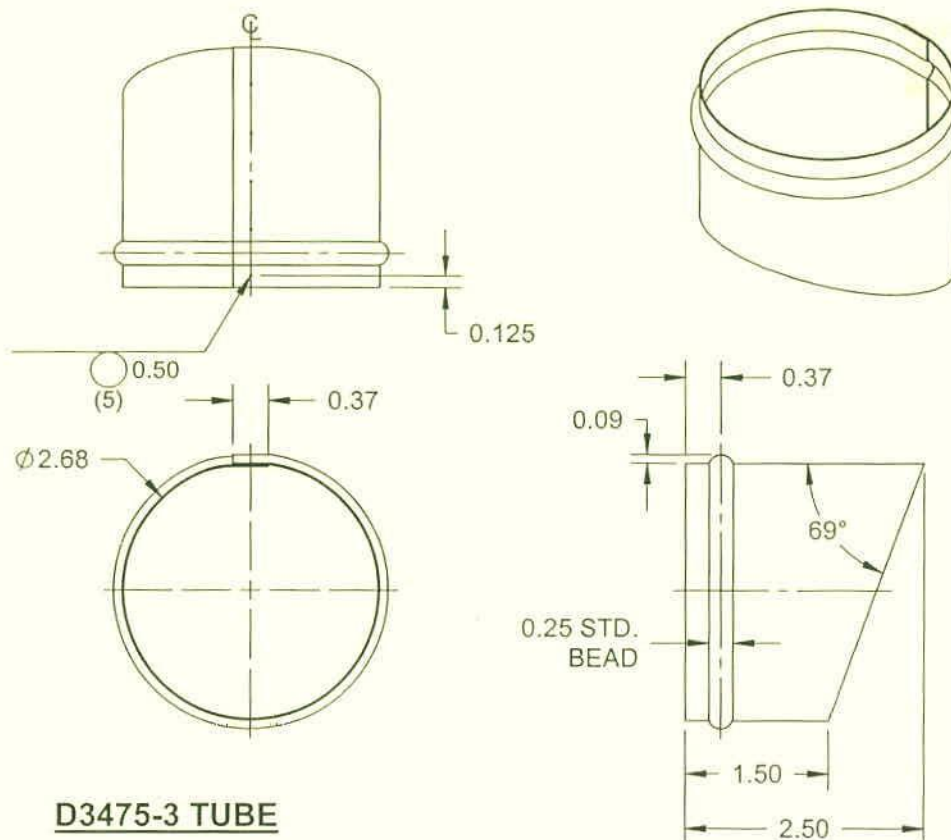
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

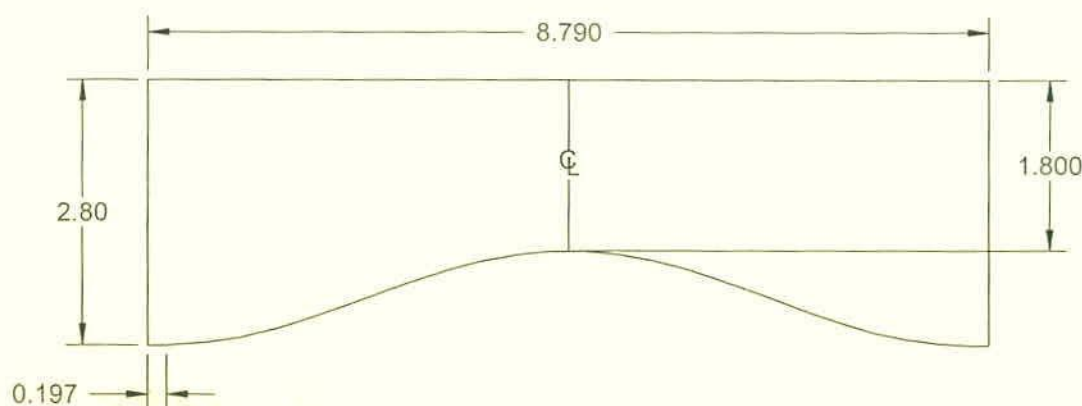
NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3475	REV. A SHEET 3 OF 6
DATE 06.01.24		TITLE DUMP INLET	SCALE 1:2



**D3475-3 TUBE**



**D3475-3F TUBE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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[illegible]

INDUSTRIAL TASKS P.O. - 110880 S.O. - 374786 TERM 01 - 3 SHITS

3/17/06

604-546-453 8/11/2020





003

INDUSTRIAL LASER CUTTING

03/17/2006 14:37 FAX 604 946 4153

Ryerson 3/17/2006 1:57 PAGE 002/002 FAX Server

T-726 P.008/015 F-537

253-288-3833

FROM-INTEGRIS

MAY-17-2006 16:05



**AK Steel Corporation**  
**Metallurgical Test Report**  
**Coshocton Works**  
**Coshocton, OH 43812**

Page 2

Load No. 7410672

BRN No. 7410672

C O S H O C T O N	INTEGRIS METALS PO BOX 390 MINNEAPOLIS, MN 55440	S H I P  T O	INTEGRIS METALS 305 "B" STREET AUBURN, WA 98001	MILL ORDER NO. 272345-0191	PROCESSOR ORDER NO. 427136-01	BUYERS ORDER NO. 427136-01
				PART NO. 74251487	ENGLISH UNITS - PRODUCT - METRIC UNITS .9175 NOM 48.000 X COIL	

PARENT COIL ID	POS (W/T)	DIR (L, T, D)	COND	ASTM A 283 PRACTICE	BEND 180 IT						
0549919-02	T		ASTM	PASS	PASS						
PARENT COIL ID	POS (W/T)	DIR (L, T, D)	COND	%ELONG 2 INCH MEASURED	TENSILE STRENGTH (KSI)	Y.S. 3% OFFSET (KSI)	ROCKWELL HARDNESS T <sub>01</sub>	ROCKWELL HARDNESS Front			
0549919-02	F	T	ASTM	71.0	92.8	33.1	B 72	B 74			
PARENT COIL ID	POS (W/T)	DIR (L, T, D)	COND	BEND 180 IT							
0549919-02	F		ASTM	PASS							

THE CHEMICAL ANALYSIS AND PHYSICAL AND MECHANICAL TESTS REPORTED ABOVE ARE CORRECT  
 AS CONTAINED IN THE RECORDS OF THE CORPORATION.

ALL TESTING IS DONE IN ACCORDANCE WITH ASTM STANDARDS UNLESS OTHER UNIFORMS NOTED

AK Steel Corporation

MAY060049 5/19

WONED

*Grant Rayson*  
 APPLICATION ENGINEER

DATE 05/19/2006 TIME 10:42 PM

\*THIS CERTIFIED TEST REPORT HAS BEEN DELIVERED TO A CONSIGNEE OF MATERIAL PURCHASED FROM AK  
 Steel Corporation. TO AVOID THE POSSIBILITY OF ITS MISUSE OR DELIVERY OF THE REPORT TO A  
 THIRD PARTY IT MUST BE RECAPTURED BY AND UNDER THE NAME OF SUCH CONSIGNEE\*

03/17/2006 14:18 FAX 6042729137

INTEGRIS METALS

002/004





## MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN  
740 IMPERIAL ROAD NORTH

Page : 1  
Heat/Lot : 86K8  
TIN : B42748

Sold To: INTEGRIS METALS, LTD.  
7910 40TH STREET SE  
CALGARY, AB T2C2Y3

Ship To: \*\*\*CUSTOMER PICKUP\*\*\*  
4375 14TH STREET NORTHEAST  
CALGARY  
ABT3K7A9

### Vendor Information

Cust PO #: 416824

Cust PO DT: 11/03/05

### Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.  
ASTMA240/04a 480/04a, 666/03, ASMESA240/04-A05, 480/04-A05, SA666/04  
QQS766D-A X HG FRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS  
CORROSION: ASTM A262/02aE; 180Bend-OK  
Buyer Part: 4288441  
304 2B .1305 IN 48 IN 96 IN  
Country of Origin: UNITED STATES

### Mechanical Tests

		UOM	L	O		UOM	L	O
Yield Strength - 0.2% Offset	40	KSI	F	TRANSV				
Tensile Strength (UTS)	93.3	KSI	F	TRANSV				
Rockwell B	85		F	TRANSV				
Pct Uniform Elong 2 In/50mm	57.01	PCT	F	TRANSV				
Rockwell A	85		T	TRANSV				

### Chemical Composition

C Carbon-Pct	.059	CR Chromium-Pct	18.360
CU Copper-Pct	.342	MN Manganese-Pct	1.643
MO Molybdenum-Pct	.285	N Nitrogen-Pct	.037
NI Nickel-Pct	8.150	P Phosphorus-Pct	.029
SI Silicon-Pct	.289		

### Comments





# MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN  
740 IMPERIAL ROAD NORTH

Page : 2  
Heat/Lot : 86K8  
TIN : B42748

Material free from mercury contamination. No weld repairs.  
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 QQS763F Cond A  
This document certifies the material has been tested in  
accordance with applicable specifications described herein  
and has met those requirements.

QA by ERIC HESS 02/01/2006

## Miscellaneous Data

GURLEPH, OMN K123  
Control #: 50C60214  
Part #: 74270441  
.135 X 48 X 96

Date: 03/17/06

SOLD TO: INDA LASHA

TPO 110880

S/O 90-374786 - 02

*Edg* 3/17/06

The Chemical Analysis and Mechanical Test  
data was received via EDI from the above  
mentioned vendor.

INTEGRIS METALS, LTD.

